Work Orde		687		*996	87*						Page 1
Revision ID:	D2232-1 Basket Hinge			Accept	*N900	040	100	<b>)*</b> s	Setup Star	171	S1* S2*
Start Date: Required Date: Reference:	4/11/13 4/11/13	<b>Start Qty:</b> 12.00 <b>Req'd Qty:</b> 12.00	*12* *12*		Cust Item Customer:					·	. 12
Approvals:		n: MUJ				)ate:		F	Run Star Stop	" <b>[V</b> ]	R1*
Sequence ID/ Work Center ID		Operation Description	Date:	SPC (Y/N):  Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	R2* Insp. Stamp
Draw Nbr		ision Nbr		110113					~~	Trainber	
D2232	Rev	C									
*100 *100* Waterjet FLOW CNC Waterje	et			0.00 0.00 Prog Rev.	2-			/2	0		JMB-5-1
110		Deburr if nec	•			ŧ					
*11 <b>∩</b> *		. Memo		0.00				_17_	_0		Jm 13-5-16
Quality Control				•							
<sup>120</sup> *1 <b>ク</b> ∩*		QC8- Inspect parts - second	nd check	0.00				12	•		
QC Quality Control		Memo		0.00 BS	$ \Box $						

Quality Control

											DQA:	Date	e:	
NCR: Y	'es	/ No				WORK ORDER NON-C	O	NFORM	MANCE / UPDATI		OA Classel	 Date		
					-						QA Closed:	Date	<del>.</del>	
Work Orde	r.				:	DISPOSITION			A	GAINST DE	PARTMENT	/PROCESS		
WOIR OIG	-'' –					Rework			Skid-tube Cro	osstube		Water Jet	En	gineering
Part N	lo.					Scrap			<b>⊢</b>	mall Fab	Pro	d. Eng. Coor.		Quality
	-					Use-as-is		Therm	oforming F	inishing	Rec/Sto	re/Packaging		Other
NCR N	lo					Work Order Update			Large Fab Cor	mposite		Supplier		
Root					Descri	ption of work order update		Initial	Action		Sign &			
Cause		Date	Step	Qty	C	or Non-conformance	Ct	nief Eng	Description	n	Date	Verification		QC Inspector
Doc/Data													Ì	
Equip/Tooling														
Operator							1							
Material														
Setup														
Other													1	
Process	Ш									-				
Supplier	Ц			1										
Training	_													
Unapproved							<u>L</u>							
		<u> </u>					AUI	T CATE	SORY					
Landii	<u> </u>					General	$\overline{}$	]:_			Ovalized	Г	70-0-	sure/Forced
		Bending			o/s	Bend BOM/Route	⊢	Grain Hardwa		<b> </b>	Ovalized Over/Under	toloranco		perature/Cure
	$\vdash$	Centre No	ot Concer	itric to	<sup>0/3</sup>  -	BOM/Route	⊢		_	<b></b>	Part Incorre	<del> -</del>	Wel	•
	$\vdash$	Cracks	Crimonad		$\vdash$	Broken/Damaged	-	4 `	on Incomplete ions Incomplete/Unclea	<u> </u>	Part Income	<b>)</b>	→	ng Stock Pulled
	-	Crushed/	unmpea		-	Burrs	-	Mainte	•		Part Lost/Mil	331118		ing Stock Funeu
	-	Cuffs Heat Trea	.+		-	Contamination Countersink	<u> </u>	Mislabe		<u> </u>	Positioned V	Vrong		
	ш			Tuba	<b>—</b>	Cut Too Short	$\vdash$	Misread		<del></del>	Power Loss/		Othe	or
	1	Inspectio	ıı ətrib iü	rube	1	Lent 100 Short		Innividual	l	1	LOMEL FO22	ouige [	Jour	

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

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Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

Work Ord April-11-13 2:4		<b>687</b> : .		*996	87*		-					Page 2
Item ID: Revision ID: Item Name:	D2232-1 Basket Hinge			Accept	*N900	<u>1040</u>	100	* 9	Setup	Start Stop	*N:	S1*
Start Date: Required Date Reference:	4/11/13 : 4/11/13	<b>Start Qty:</b> 12.00 <b>Req'd Qty:</b> 12.00	*12 *12		Cust Item l Customer:						14.	
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):		ate:		1	Run	Start Stop	*NI *NI	R1* R2*
Sequence ID/ Work Center I 130 *130* Packaging	D	Operation Description Identify as per dwg & Sto	ck Location:	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Qty		Reject Number	Insp. Stamp
Packaging  140  *140* QC  Quality Control		*****STOCI QC21- Final Inspection -  Memo	K IN BASKET CELL*  Work Order Release	0.00						13/	3/01	1351
								٠.	M			

NCR: Yes	s / No	

								•		DQA:	Date	::		
NCR: Y	es / No				WORK ORDER NOT	N-COI	NFORM	MANCE / UPDATE						
					·				QA	Closed:	Date	<u>:</u>		
Work Orde	r:				DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Part No.				Rework Scrap Use-as-is		ı	Skid-tube Crosstube Small Fab Thermoforming Finishing			Water Jet od. Eng. Coor. re/Packaging	Engineering Quality Other		
NCR No.					Work Order Update			Large Fab Composite	_	1100,010	Supplier			
Root	<u> </u>	T		Descri	iption of work order update	e I	nitial	Action		Sign &	1			
Cause	Date	Step	Qty	1	or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector		
Ooc/Data														
quip/Tooling														
Operator [														
Material [								•			ļ			
etup					•									
Other														
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Inapproved											<u> </u>			
						FAUL	T CATE	GORY						
Landir	ng Gear				General						_	_		
	Bending				Bend		Grain		$\mathbf{H}$	alized	L	Pressure/Forced		
	Centre N	lot Conce	ntric to (	o/s	BOM/Route		Hardwa	re	∐ov	er/Under	tolerance	Temperature/Cure		
	Cracks				Broken/Damaged		Inspecti	on Incomplete	Pa	rt Incorre	ct _	Weld		
	Crushed	/Crimped			Burrs		Instruct	ions Incomplete/Unclear	Pa	rt Lost/M	issing	Wrong Stock Pulled		
	Cuffs				Contamination		Mainte	nance	Pa	rt Moved				
ĺ	Heat Tre	eat			Countersink		Mislabe	eled	Po	sitioned <b>V</b>	Wrong			
	Inspection	on Strip in	Tube		Cut Too Short		Misread	i	Po	wer Loss/	/Surge	Other		
	Ripples i	n Bend			Drill Holes		Offset							
	Torque	Waves in I	Extrusio	,	Drawing		Out of 0	Calibration						
Ì	Turning	Sequence	<u> </u>		Finish		Out of 9	Sequence						
	Wave/Twist in Tube Folio						Outside	Dimensions						

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## **Picklist Print**

April-11-13 2:46:45 PM

Work Order ID:

99687

Parent Item:

D2232-1

Parent Item Name:

Basket Hinge

**Start Date: 4/11/13** 

Required Date: 4/11/13

**Start Qty: 12.00** 

Required Qty: 12.00

Comments:

IPPB01.06.07Now laser cutEC

IPP Rev:C Now on Waterjet 06-11-21 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
<b>M304S11GA</b> 304/316 0.125 Sheet		Purchased	No			100	sf	207.0300	0.0243	0.30 <del>694</del> 68			J <u>m13</u> -5.
				<b>Location</b>		Loc Oty	Lo	c Code					e.
				MAT020		207.03				<u> </u>			
	*			12252	21	30.03							
				124445	5	177			19	4442			

age 1

NCR: Y	NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE													
-								_			QA Closed:	Date:		
Work Orde	:r: _					<b>DISPOSITION</b> Rework	1		AGAINST DEPARTIMENT/PROCESS  Skid-tube Crosstube Water Jet Engineering					
Part No				Scrap Use-as-is Work Order Update		I Thern	Machining noforming	Small Fab Finishing Composite	4	d. Eng. Coor. re/Packaging Supplier	Quality Other			
<b>D</b> 4			<u> </u>	ī	Descri	iption of work order update	Т	Initial	Action	<u> </u>	Sign &		T	
Root Cause		Date	Step	Qty		or Non-conformance		nief Eng	Descript		Date	Verification	QC Inspector	
Doc/Data	+	Dute	Step	αι,		or non comormance	+ -		3000.16					
Equip/Tooling	$\dashv$													
Operator	$\exists$											:		
Material	ᅥ													
Setup	$\neg$											1		
Other	$\neg$			ļ ,						•		•		
Process					3,					·		·		
Supplier	$\neg$												•	
Training	╗													
Unapproved														
						, i	AUI	LT CATE	GORY					
Landi	ng G	iear				General		_			-		-	
		Bending				Bend	L	Grain			Ovalized		Pressure/Forced	
:		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure	
		Cracks				Broken/Damaged	<u>_</u>	<b>-1</b> '	on Incomplete		Part Incorre	ct	Weld	
		Crushed/	Crimped		L	Burrs	$\perp$	Instruct	ions Incomplete/Unc	clear	Part Lost/Mi	ssing	Wrong Stock Pulled	
	Ш	Cuffs				Contamination	L	Mainte	enance		Part Moved			
		Heat Trea	at		L	Countersink		Mislabe	eled		Positioned V		1	
	Ш	Inspectio	n Strip in	Tube		Cut Too Short	L	Misread	i	Ĺ	Power Loss/	Surge	Other .	
		Ripples in	Bend			Drill Holes	<u>_</u>	Offset						
		Torque W	/aves in I	Extrusio	n	Drawing		Out of 0	Calibration					

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

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DART AEROSPACE LTD	Work Order:	99687
Description: Basket Hinge	Part Number:	D2232-1
Inspection Dwg: D2232 Rev: C	1	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.006/-0.001	0.262"	_		Ü	Theme 1
1.750	+/-0.010	1.751"	_		V	
0.750	+/-0.010	0.750"	_		V	
2.000	+/-0.010	2003"	_		V	
R0.125	+/-0.010	0.125"	-		RG	
R0.500	+/-0.010	0.500"	_		RG RG	
1.250	+/-0.010	1.250"			V	
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Measured by: Jm	Audited by:	27	Prototype Approval:	N/A
Date: 13-5-16	Date:	K517	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.05.10	New Issue	KJ/JLM a	B
			· · · · · · · · · · · · · · · · · · ·	



